

Work Order ID 55818

February 2, 2010 1:43:06 PM



Page 1

Item ID: D3494-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Stub Cover

Start Date: 2/02/10 Start Qty: 10.00



Cust Item ID:

Required Date: 2/05/10 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *RP*Date: *10-2-02* Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3494

Rev C

100

0.00



Waterjet

FLOW CNC Waterjet

304.063

Memo

1-Cut as per Dwg

Dwg Rev: *E*Prog Rev: *C*

2-Deburr if necessary

0.00

B 10-2-12

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

*B 10-2-12***SCRAP**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

8/10/02/17



QC

Memo

0.00



Pb ->

Quality Control

130

Bend as per dwg

0.00



Brake NC

Memo

0.00

Brake NC

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

SCRAP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/02/17	#120	Took Qh x1 For inspection template	S	10/02/17	x1		S 10/02/17

Part No: D3494-1 PAR #: NCK10-037 Fault Category: Eng-drawing NCR: Yes ☒ No ☐ DQA: / Date: 10.03.17
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: / Date: /

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/03/01	#30	After Bending the First Part it was found out that the Flat Pattern & Dwg are wrong. There is a drawn discrepancy between	/QS142	→ Scrap & Destroy Qty x14 And the template for ac. (total 15 parts).	SP 10/03/01	S 10/03/19	/QS142	S 10/03/01
		He Revises Dwg & the Prob. R.C. Eng drawing.	/QS142	→ issue an NCR/Parts Fix Problem.	/10/03/19	S 10/03/19	/QS142	S 10/03/01
			/QS142	→ Put parts & Dwg on under review	/10/03/19	S 10/03/19	/QS142	S 10/03/01

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Item Name: Stub Cover

Start Date: 2/02/10

Start Qty: 10.00



Cust Item ID:

Required Date: 2/05/10

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Stop



Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

Memo

0.00

160



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

170



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Memo

0.00

SCRAP

W/O:		WORK ORDER CHANGES					
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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

SCRAP

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 55818



Parent Item: D3494-1



Parent Item Name: Stub Cover

Start Date: 2/02/10

Required Date: 2/05/10

Comments: IPP Rev:A New Issue 06-05-18 JLM
IPP rev B ecn 888 06.12.13 EC

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No				sf	204.6899	7.2000	11,		



304/316 Sheet .063



B10-2-12

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

106860

111924

112442

113295

204.6898737

8.0295

25.1689737

29.8865

141.6049

15

113295

SCRAP

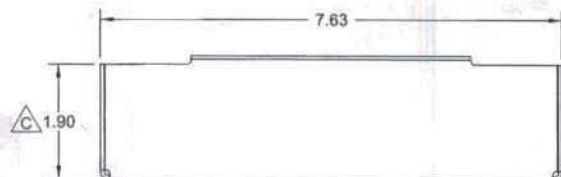
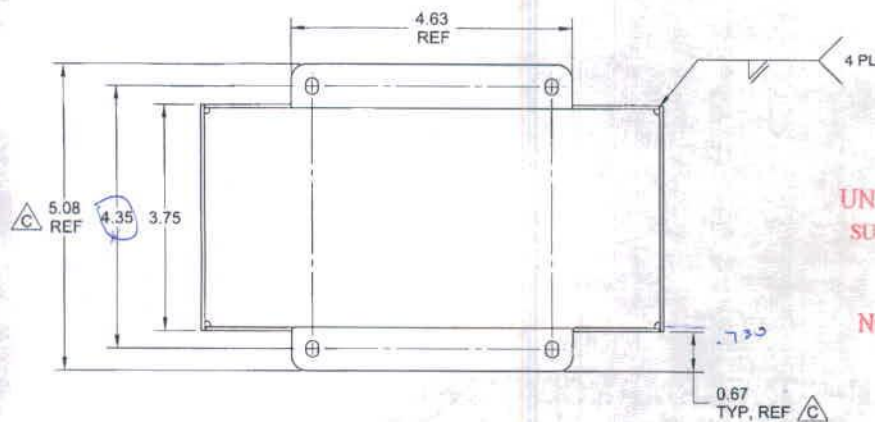
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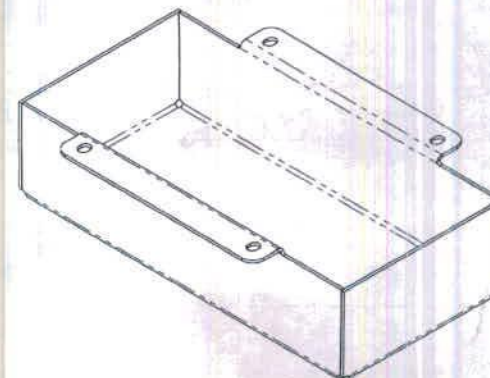


D3494-1 STUB COVER

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO. 55818

10-2-02



RELEASED
04/04/01

SCRAP

NOTES:

- 1) MATERIAL: MAKE FROM D3494-1F
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3494-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.44 lbs
- 8) WELD PER DART QSI 004

C	DRAWING TRANSFERRED TO "B" SIZE. GENERAL REVISION TO FLAT PATTERN SEE PREVIOUS REV FOR DETAILS. C8-1 DIM 5.08 WAS 5.05 AND WAS A "HARD CALLOUT". C5-1 Ø 0.67 DIM WAS 0.65, B8-1 1.90 DIM WAS 1.86 B3-1 & 2.04 DIM WAS 2.00. REFER TO PAR 08-003 FOR FURTHER DETAILS.	AJS	08.10.31
B	REVISED FLAT PATTERN. BENDING DIMENSIONS, Ø 0.208 X 0.288 SLOTS WERE Ø 0.208 HOLES.	MB	06.11.28
A	NEW ISSUE	MB	06.01.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3494	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STUB COVER	NTS
DATE	08.10.31	COPYRIGHT © 2006 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

4.158
4.160

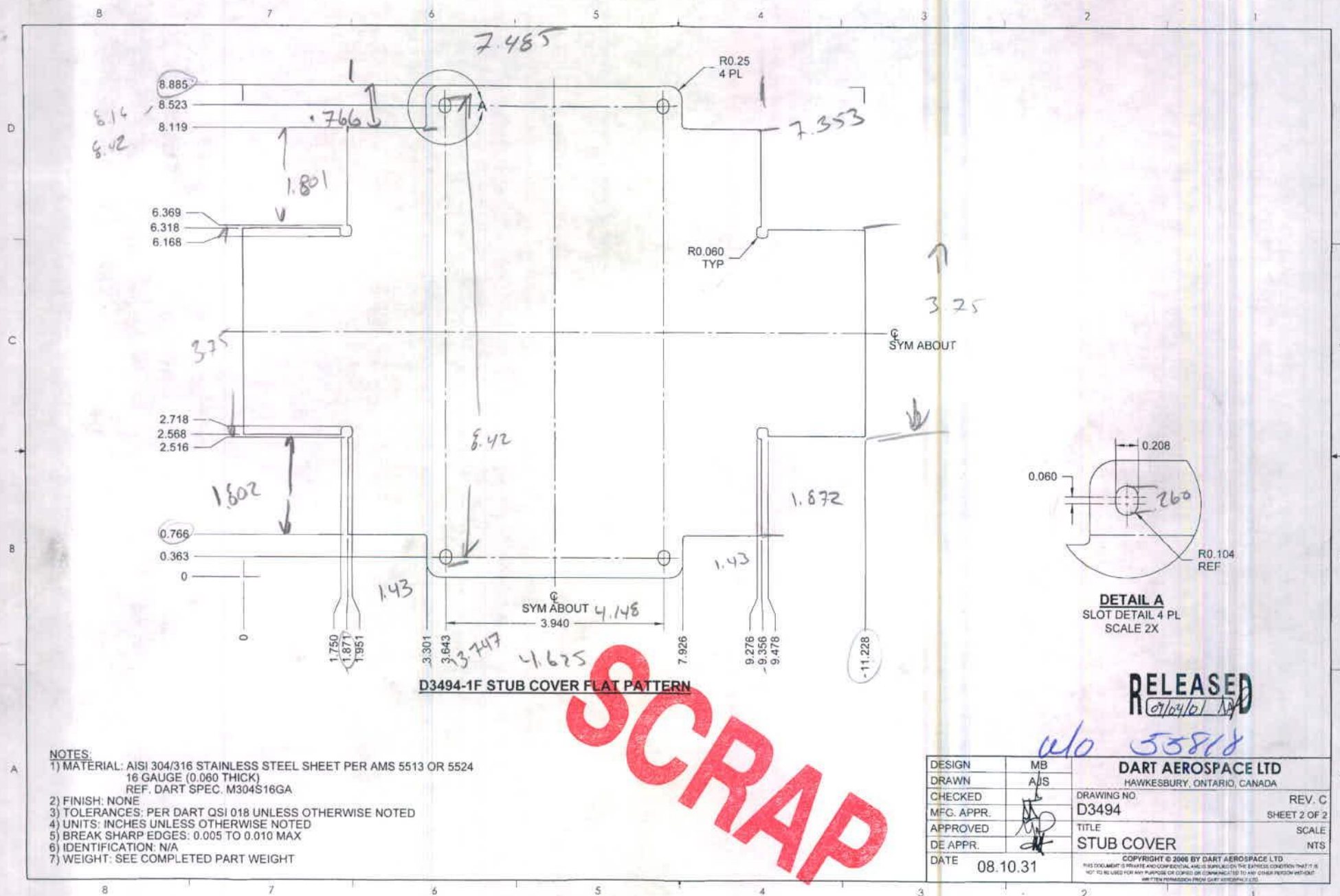
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2000

